

# Work Order ID 58350-2

Monday, May 03, 2010 3:14:31 PM



ASAP

Page 1

Item ID: D3643-2

Accept



Setup Start



Revision ID:

Item Name: Stiffener

Stop



Start Date: 5/4/2010

Start Qty: 15



Cust Item ID:

Required Date: 5/6/2010

Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-5-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3643

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3643 ☒ Dwg Rev: A ☐ Prog Rev: A ☐ 2-  
Deburr if necessary

10-5-3



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-5-3

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/10/4

counts  
10-5-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 58350

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Item ID: D3643-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Stiffener

Start Date: 5/4/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 5/6/2010 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3643

0.00

0.00

SPS 10/05/04

15

140



Small Fab

Small Fab

Small Fab

Memo

C'sink as per Dwg D3643

0.00

0.00

SPS 10/05/04 (15)

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

SPS 10/05/04

(15)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Work Order ID 58350**

Monday, May 03, 2010 3:14:31 PM



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Item ID: D3643-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Stiffener

Start Date: 5/4/2010

Start Qty: 10.00



Cust Item ID:

Required Date: 5/6/2010

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

(15)

BR 10-5-4.

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

→ m.h 10/05/04

(15X)

180



Packaging

Packaging

Identify as per dwg &amp; Stock Location: 243

0.00

Memo

0.00

10-5-5 (15X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Work Order ID 58350**

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Page 4

Item ID: D3643-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Stiffener

Start Date: 5/4/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 5/6/2010 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/06 *[Signature]*

C&amp;L 10/5/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, May 03, 2010 3:14:30 PM

Work Order ID: 58350



Parent Item: D3643-2



Parent Item Name: Stiffener

Start Date: 5/4/2010

Required Date: 5/6/2010

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	506.7000	0.1475			



2024-T3 .040 sheet



B10-53

Location

Loc Qty

Loc Code

MAT

96

114415

96

MAT22

410.7

110305

136.7

111786

18

112291

32

112331

64

113162

160

111786

(21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Ø0.098 THRU  
C'SINK Ø0.179 X 100°  
(4 PLACES)

Ø0.266 (2 PLACES)

BEND LINE

GRAIN  
DIRECTION

1.90

1.36

0.96

1.25

0.344  
(TYP)

2.000

4.49

9.00

9.75

1.16

0.81

R0.25 (TYP)

2.240

1.117

**D3643-1F FLAT PATTERN  
(D3643-2F OPPOSITE)**

ENSURE THAT COUNTERSINKS  
ARE ON THIS SIDE OF THE PART

0.60 (REF)

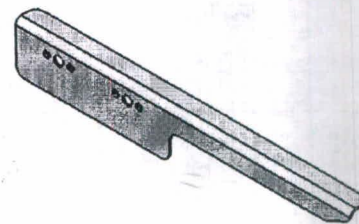
1.41

R0.13

**D3643-1 STIFFENER (REPLACES GENEVA P/N G10610-2)  
D3643-2 OPPOSITE (REPLACES GENEVA P/N G10610-1)**

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037  
(REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3643-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs



#58350

**RELEASED**  
07.09.07

A	NEW ISSUE; REPLACES G10610	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DTI	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CE		
CHECKED	EB	DRAWING NO.	REV. A
MFG. APPR.	EB	D3643	SHEET 1 OF 1
APPROVED	EB	TITLE	SCALE
DE APPR.	EB	STIFFENER	2:3
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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